



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

URGENT

D2893-1
Job Sheet 171090



Part No: D2893-1

Job Qty: 12 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/28/18

Job Tracking No:

Due Date: 2/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		1/31/18	0.00	0.00	Start Up Machining-1		Kt 18-02-02
100	CNC Vertical Machining	12 pcs		2/1/18	0.33	23.53	HAAS1-2		18-02-21
120	QC	12 pcs		2/1/18	0.00	0.00	QC8 Machining-1		18-02-05
130	Crosstubes	12 pcs		2/2/18	0.00	2.00	Crosstubes-2		18-02-07
140	QC	12 pcs		2/2/18	0.00	0.00	QC3		18-02-07
170	Packaging	12 pcs		2/2/18	0.00	0.00	Packaging3-1		18-02-07
180	QC21-SA	12 Ea		2/2/18	0.00	0.00	QC21		18-02-07

Part Op 100 - 1-Machine as per Folio FA081

Descriptions: 130 - Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG050

138381 exp 11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK078	6	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches	+ 0.020 - 0.000	3.005 2.985	
2	2.750 Support	0.440Inches	+ 0.020 - 0.000	0.460 0.440	
3	2.750 Support	0.125Inches	+ 0.035 - 0.000	0.160 0.125	
4	2.750 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
5	2.750 Support	0.188Inches	+ 0.005 - 0.000	0.193 0.188	

5037938

DART
AEROSPACE
S038538

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Support

PART NO: D2893 – 1

Original Serial #: S038538

Revision:

Operation: Start up Operation 02/02/18

Change No:

Job No: 171090

6	2.750 Support	0.125Inches	+ 0.035 - 0.000	0.160 0.125
7	2.750 Support	0.140Inches	+ 0.020 - 0.000	0.160 0.140
8	2.750 Support	1.360Inches	+ 0.040 - 0.000	1.400 1.360
9	2.750 Support	0.040Inches	+ 0.020 - 0.000	0.060 0.040
10	2.750 Support	1.190Inches	+ 0.040 - 0.000	1.230 1.190
11	2.750 Support	0.010Inches	+ 0.010 - 0.000	0.020 0.010
12	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053
13	2.750 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240
14	2.750 Support	2.518Inches	+ 0.020 - 0.000	2.538 2.518
15	2.750 Support	84.390Inches	+ 6.000 - 0.000	90.390 84.390
16	2.750 Support	0.261Inches	+ 0.005 - 0.000	0.266 0.261
17	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053

Plex 1/29/18 5:41 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	171090
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005	2.991	2.991	2.992	2.998	3.000	3.000
AB	0.440	0.460		0.450	0.450	.455	.455	.458
AC	0.125	0.160	0.140	.160	0.160	.148	.150	.141
AD	0.040	0.060		.050	0.050	.053	.053	.053
AE	0.188	0.193		0.188	0.188	.188	.148	.188
AF	0.125	0.160		.144	0.144	.141	.141	.142
AG	0.140	0.160		.152	0.152	.156	.155	.156
AH	1.360	1.400		1.381	1.381	1.382	1.382	1.382
AI	0.040	0.060		0.048	0.048	.049	.049	.050
AJ	1.190	1.230		1.224	1.224	1.220	1.222	1.221
AK	0.010	0.020		0.010	0.010	.010	.010	.010
AL	0.053	0.073		0.0625	0.0625	.063 R	.063 R	.063 R
AM	0.240	0.260		0.250	0.250	.250 R	.250 R	.250 R
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	88.00	88.00	88.00
AP	0.261	0.266		0.261	0.261	.261	.261	.261
AQ	0.053	0.073		0.0625	0.0625	.063 R	.063 R	.063 R
AR								
AS								
AT								
Accept/Reject						N.M.	N.M.	

Measured by:	DAS 1 9-89	N.M. 20/4/03	Date:	18-02-02
Audited by:	on		Date:	18/02/05
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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DART AEROSPACE LTD		Work Order:	171090
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6/1	7/2	8/3	9/4	10/5
HAAS Section								
AA	2.985	3.005		3.001	3.000	2.999	3.002	3.002
AB	0.440	0.460		.458	.456	.458	.458	.458
AC	0.125	0.160		.134	.136	.138	.139	.138
AD	0.040	0.060		.051	.051	.053	.051	.051
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.138	.138	.142	.140	.144
AG	0.140	0.160		.158	.157	.157	.156	.155
AH	1.360	1.400		1.382	1.383	1.384	1.382	1.382
AI	0.040	0.060		.051	.053	.052	.050	.051
AJ	1.190	1.230		1.223	1.222	1.221	1.219	1.220
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AM	0.240	0.260		.250 R	.250 R	.250 R	.250 R	.250 R
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		88.00°	88.00°	88.00°	88.00°	88.00°
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AR								
AS								
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Accept/Reject				N/A				

Measured by:		Date:	
Audited by:	<i>[Signature]</i>	Date:	18/02/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	171090
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Measured by:	MM	2014/02/21	Date:	
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Preliminary Approval:			Date:	

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